

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002010**Date Inspected:** 21-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present observe production welding of the deck plate U-rib splice welds and perform random Visual Testing (VT) of the Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

The Caltrans QA Inspector observed ZPMC welder Mr. Zhao Chengshuang performing Flux Cored Arc Welding (FCAW) on U-rib Complete Joint Penetration (CJP) splice welds DP408-001-194 and DP138-001-190 in the 3G position. Splice welds were back gouged to sound metal, ground smooth, and welding completed. The following parameters were recorded from weld DP138-001-190, amperage 211, voltage 24.0, travel speed of 109 mm/min., with a heat input of 2.78 kJ/mm. The above mentioned welding appeared to be in conformance with the posted welding procedure specification, WPS-B-T-2233-B-U2-F.

The Caltrans QA Inspector performed Magnetic Particle Testing (MT) of Side plate SP411-001 stiffener welds 001 through 010. Approximately 10 percent of welding was tested with no relevant indications observed within the tested area. Please see MT report TL-6028 generated on this date for further information.

Summary of Conversations:

No relevant conversations occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

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for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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